

Attorney Docket No: A 91833

Method for making a CylinderBackground of the Invention

United States Patent 6,041,499 discloses a method wherein
5 a cylinder housing is cast having a cylinder wall which
delimits an interior space for accommodating a reciprocating
piston. The cylinder is provided for a two-stroke engine and
therefore transfer channels enclosed in the cylinder wall are
provided. The combustion chamber is delimited by the piston.
10 The supply of the combustion chamber in the cylinder with the
fuel mixture or air is ensured via the transfer channels in a
manner known per se. The transfer channel runs essentially
axially in the cylinder wall and, to connect the transfer
channel to the interior of the cylinder, a radial control
15 window is provided in the cylinder wall which is cyclically
covered and again cleared by the stroke piston during operation
of the engine.

In the known method, a blank of the cylinder housing is
first cast which is provided only with the flow channels
20 enclosed in the cylinder wall so that the blank cylinder body
can be cast with a high degree of efficiency and a savings of
manufacturing costs. In a second method step for making the
cylinder, a control window is machined in for each transfer
channel with a non-contact machining process, for example, an
25 electric discharge machining process. The known method assumes
that a precise machining in the formation of the control window
in the cylinder wall is only possible with a non-contact
machining process. In the known non-contact machining process
of the control windows, a work tool is introduced into the cast
30 blank cylinder body and is brought into position at the wall

section of the cylinder wall where the control window is intended to be cut out in the cylinder wall for connection to with the still hidden transfer channel.

5 The manufacture of cylinders with the known method, however, requires costly processing machines to effect a non-contact cutting out of the control windows in the cylinder wall. In the manufacture of cylinders for small internal combustion engines such as those used in portable handheld work apparatus, the non-contact machining leads to high
10 manufacturing costs of the cylinder and therefore of the engine. This is especially unacceptable when manufacturing in large quantities.

Summary of the Invention

15 It is an object of the invention to provide a method of the kind described above which makes possible a rapid and cost effective manufacture of the cylinder.

The method of the invention is for making a cylinder for an internal combustion engine. The method includes the steps of: casting a cylinder housing having a cylinder wall
20 delimiting an interior space for accommodating a reciprocating piston; forming a control window into the cylinder wall with a multi-step machining of the cylinder wall which includes: a first step of forming a breakthrough in the cylinder wall utilizing a chip removing work tool having a rotating primary
25 movement; and, a second step of widening the breakthrough to a wanted dimension of the control window utilizing a work tool.

According to the invention, a cost-effective manufacture of the cylinder is achieved with a two-stage machining in the formation of the control window in the cast cylinder housing.
30 In a first step, the cylinder wall is broken through in the

intended location of the control window with a chip-removing tool with a rotating primary movement and, in a second step, the breakthrough is widened to the planned dimensions of the control window with a work tool having a preferably linear primary movement. In this way, a large part of the required material removal for cutting out the control window is carried out with a rotating primary movement with a cost-effective manufacturing method. Burrs remain from the rotating primary movement of the work tool in the first step and these burrs can be cleanly removed with a straight-line machining and the precise dimensions of the control window can be machined. The machining according to the invention in the second step can be cost effectively carried out preferably with a work tool having an especially straight-line primary movement and, as may be required, even with the same processing machine.

The combination according to the invention of two machining steps with a first rotating machining operation and thereafter the completion of the control window with another work tool makes possible a precise formation of the control window for each transfer channel with the manufacturing costs clearly reduced relative to the known method.

The breakthrough of the cylinder wall in the first step of forming the control window advantageously takes place by milling. A breakthrough can be formed with a dimension corresponding already to the intended elevation of the control window in axial direction of the cylinder when a side-milling cutter is used having the cutting width corresponding to the elevation. The machining of the control window in the cylinder wall can be further accelerated when the first machining step takes place with a work tool having a rotating primary movement

up to a cut of the work tool into the cylinder wall corresponding to the intended width of the control window in the peripheral direction of the cylinder.

5 The second machining step takes place preferably with a tool having a linear primary movement, preferably, with a drilling tool and especially a broach or scraping tool. The tool to be guided linearly is aligned into a work position by a machine tool driving the work tool and is driven by the transverse feed movement of the machine tool in the primary movement direction. Preferably, the machining with the linear primary movement takes place with a rotatingly driven work spindle. The feed movement in the rotational operation of the spindle forms the primary movement of the tool in the linear movement. In this way, the first processing step with a rotating cutting movement and the linear primary movement in 15 the second step can be carried out with the same machine tool and, in this way, the machining time is reduced with a very short changeover for the new work tool for the second machining step.

20 In a further embodiment of the invention, the rotatingly driven work spindle with the work tool to be guided linearly is brought into the work position within the cylinder housing for the second step and the work tool is rotated in a direction with a suitable attack angle with reference to the position of the control window. Thereafter, the work spindle with the work tool is moved back and forth in the straight line primary movement and the chip-removing machining operation is undertaken. At the end of the machining, a removal of burrs can be undertaken on the finished cut-out control window and a 25 cleaning of the edge of the control window can be undertaken.

The work tool passes over the edge of the control window with rotating movements matched to the stroke position of the work tool.

In another embodiment of the invention, the second
5 machining step can also take place without contact, preferably, by erosion or utilizing a laser.

Brief Description of the Drawings

The invention will now be described with reference to the drawings wherein:

- 10 FIG. 1 is a perspective view of a cylinder housing;
 FIG. 2 is a perspective plan view of the cylinder housing;
 FIG. 3 is a longitudinal section view of a cylinder housing during the machining with a rotating work tool;
 FIG. 4 is a cross section of the cylinder housing during
15 the machining with a rotating work tool;
 FIG. 5 is a longitudinal section view of the cylinder housing during the machining with a longitudinally-guided work tool; and,
 FIG. 6 is a cross section of the cylinder housing during
20 machining with a linearly-guided work tool.

Description of the Preferred Embodiments of the Invention

FIGS. 1 and 2 show a cylinder housing 1 for an internal combustion engine of a portable handheld work apparatus which is originally formed as a pressure die cast part and delimits
25 with a cylinder wall 2 an interior space 3 for accommodating a reciprocating piston. The cylinder wall 2 is equipped with cooling ribs 14 on its outer side for air cooling the cylinder. The cylinder housing 1 is cast integrally and is open at one end for insertion of the reciprocating piston. The open end is
30 configured with a planar flange 15 for connecting to an engine

block. Control windows 5 are machined into the cylinder wall 2 and define the openings of transfer channels 4 into the interior space 3 of the cylinder and are opened and closed during operation of the engine for the purpose of a charge exchange by the reciprocating movement of the piston. Depending upon the type of construction of the engine, the transfer channels 4 can supply air or can be supplied with an air/fuel mixture from the crankcase of the engine or from a separate unit for mixture preparation.

10 In the manufacture of the cylinder housing, the cylinder is cast in a first processing step and, in a second processing step, the radial control windows 5 are cut out as the respective ends of the transfer channels 4 via a milling machining of the cylinder wall. In this way, an integral
15 cylinder housing having a simple cast core for the interior space is produced because complicated cast cores for forming radial undercuts caused by the control windows 5 in the cylinder wall 2 are unnecessary.

The manufacturing method for forming the control windows 5
20 is explained hereinafter with respect to FIGS. 3 to 6. This manufacturing method can be applied to any formation of essentially radial breakthroughs in the cylinder wall. Accordingly, also inlet channels and outlet channels can be machined in this way or, in addition to the type of
25 construction shown in FIGS. 1 and 2, flow channels can be produced which are connected to the outside of the cylinder wall as can transfer channels enclosed integrally in the cylinder wall and opening into the combustion chamber.

FIG. 3 shows a cross section of a cylinder housing 1 for a
30 slot-controlled two-stroke engine. The cylinder housing 1 is

manufactured as a pressure-cast part with transfer channels 4 enclosed in the cylinder wall 2. The transfer channels 4 and the interior space 3 form the hollow spaces of the cast cylinder housing 1 and are originally formed without an undercut whereby, in the cast blank of the cylinder housing 1, the accesses or openings of the transfer channels 4 to the interior space 3 of the cylinder are closed. The transfer channels lie diametrically opposite each other in the embodiment shown. The control windows 5 are formed in the cast blank by mechanical machining of the cylinder wall and define the flow connection of the channels 4 to the interior space 3. A multi-stage metal cutting or machining process is provided for cutting out the control windows 5. In a first step, as shown in FIG. 3, a side-milling cutter 7 is introduced into the interior space 3 of the cylinder housing 1. The interior space 3 is open at the flange 15. The side-milling cutter 7 is mounted at the end of a drive spindle 6 of the machine tool and is brought by the control of the machine tool into the intended work position opposite to the cylinder wall 2 via the drive spindle 6. With the side-milling cutter 7, a breakthrough 10 is cut into the cylinder wall 2 at the position intended for the control window 5. The side-milling cutter 7 with its rotating primary movement 11 is moved with a feed movement 12 in the transverse direction of the cylinder toward the cylinder wall 2 and provides the breakthrough. The width of the cut of the side-milling cutter 7 advantageously corresponds approximately to the wanted axial elevation of the control window 5 so that a one-time cutting thrust is sufficient for the first machining step.

FIG. 4 shows the side-milling cutter 7 in the machining

position in the cylinder wall 2. The cutter head 7 is moved up to a cut into the cylinder wall 2 in correspondence to the width B of the control window 5 in the peripheral direction of the cylinder. As soon as the cut in the cylinder wall

5 corresponds to the width B, the thrust movement of the machine tool is stopped and the cutter head 7 is moved out of the workpiece to permit an exchange of the work tool. A burr having a comma-shaped cross section remains on the edge of the control window 5 because of the rotating primary movement of

10 the work tool during machining with the cutter head 7. The burr is removed in the subsequent machining phase of the multi-stage machining process for forming the control window. This can be carried out without contact via erosion, laser action or like machining operation. Preferably, and after the

15 machining with the rotating cutter head 7, a furrowing tool is clamped to the work spindle 6 and is moved by the work spindle into the work position in the interior of the cylinder housing. The furrowing work tool is to be guided along a straight line and can be a broaching or reaming tool.

20 As shown in FIG. 5, the furrowing tool 8 is brought by the work spindle 6 to the axial elevation corresponding to the control window 5 in the interior space 3 of the cylinder housing 1 and, with a linear transverse movement 13, the breakthrough provided by the cutter head 7 is expanded to the

25 wanted dimensions of the control window 5. In advance of the cutting machine operation of the breakthrough with linear movements, and to align the workpiece 8, the work spindle 6 is driven by the control of the machine tool into the suitable position within the workpiece which can be pre-given by a work

30 program. With corresponding rotational movements of the work

spindle 6, the furrowing work tool 8 is aligned into the optimal attack angle with reference to the position of the control window 5 in the cylinder wall. After aligning the work tool and for milling or cutting machining, the drive spindle is moved along a straight line without a rotational movement. The thrust movement for the cutting operation determines now the primary movement of the work tool. The drive spindle operates in a plane which is changed by the thrust movement for removing the chips 9 at the edge of the control window 5. It has been shown that the thrust or feed speeds of common machine tools are adequate in order to make possible the linear primary movement in the machining of the control window in accordance with the invention. In this way, for a two-stage machining of the cast blank to form the control windows 5 in the cylinder wall 2, the same machine tool can be used for the milling or cutting operation and for the subsequent machining operation with a work tool guided along a straight line.

As soon as the control window is widened to the wanted dimensions, a cleaning of the edge of the control window or a removal of possibly remaining burrs can take place at the end of the machining in that the work tool is rotated through a suitable angle and the edge of the control window is wiped in synchronism with the straight line back and forth movement.

It is understood that the foregoing description is that of the preferred embodiments of the invention and that various changes and modifications may be made thereto without departing from the spirit and scope of the invention as defined in the appended claims.